

Work Order ID 78941

January-17-12 1:29:40 PM

78941

Page 1

Item ID: D3140-06

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Door

Stop

NS2

Start Date: 17/01/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 31/01/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: M.L.J

Date: 12/01/17

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3140	Rev F								
100		0.00							

100

Packaging

Packaging

Memo

Pick kit to ship to Delastek

0.00

1 12/09/21

110

QC4- 100% Inspect kits for completeness

0.00

110

QC

Quality Control

Memo

0.00

① 12-04-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 78941

January-17-12 1:29:40 PM

78941

Page 2

Item ID: D3140-06

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Door

Stop

NS2

Start Date: 17/01/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 31/01/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

120

Purchasing

Memo

Issue P/O: 16439

Purchase Part Number: D3140-06

Supplier: Delastek

Ship kit and make as per dwg

Conformity Certificate and Process sheet required

CL 12/02/17 ①

130

Receive & Inspect for Damage & Mat'l Certs

0.00

1/23/078 ①

130

Packaging

Memo

0.00

Packaging

140

QC6- Inspect dimensions to drawing

0.00

① ② 13.12.16

140

QC

Quality Control

Memo

0.00

Ensure a copy of certification of conformity and process sheet from Delastek is attached.

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January-17-12 1:29:40 PM

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Page 3

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Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Door

Stop

NS2

Start Date: 17/01/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 31/01/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

150

Packaging

Packaging

Identify as per dwg & Stock Location:

0.00

① 13.2.16

160

160

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

13/12/18 JH

Memo

0.00

13-12-18

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NOTE: Date & initial all entries

Picklist Print

January-17-12 1:29:44 PM

Page 1

Work Order ID: 78941

78941

Parent Item: D3140-06

D3140-06

Parent Item Name: Door

Start Date: 17/01/2012

Required Date: 31/01/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 12.01.17 NEW ISSUE DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3140-87		Manufactured	No			100	Each	0.0000	1	1			
D3140-87									**			B90778	12/09/21
Doubler													
D3140-95		Manufactured	No			100	Each	7.0000	3	3	✓		
D3140-95									**				JB
Doubler													
							<u>Location</u>	<u>Loc Qty</u>		<u>Loc Code</u>			
							ST028	7					
							52265	7					
D3140-98		Manufactured	No			100	Each	4.0000	1	1			52265
D3140-98									**				JB
Doubler													
							<u>Location</u>	<u>Loc Qty</u>		<u>Loc Code</u>			
							CA	4					
							34376	4					
D3140-241		Manufactured	No			100	Each	0.0000	1	1	✓		34376
D3140-241									**				JB
Doubler													
D3140-303		Manufactured	No			100	Each	0.0000	1	1	✓		
D3140-303									**				
Doubler													

D3140-06P

1/3/18 (1)

12/09/21

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3140
DATE		REV. F SHEET 1 OF 7
06.10.06		TITLE DOOR SCALE NTS
A	02.04.18	NEW ISSUE
B	03.01.23	REMOVE -65/-81/-83; ADD -301/-303
C	04.11.08	CHANGE DELASTEK SPEC. TEC-77; ADD PART MARKING; ADD NOTES 11, 12, 13; CHANGE ANGLE -95/-97/-98 TO 106°
D	05.11.23	ADD -103/-104/-105/-106; REMOVE -67
E	06.06.09	1.75 WAS 1.88, 4.75 WAS 4.13 ON -08/-07, 1.00 WAS 1.20 ON -09/-10
F	06.10.06	ADD NOTE 14; CORRECT PART TITLE, NOW D3140-09/-92/-104 SHOWN D3140-10/-91/-103 OPPOSITE

RELEASED
06.11.13

SHOCK ABSORBER
RETURN TO
ENGINEERING
UNCONTROLLED
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK IN PROGRESS
NO. 789-41 M.L.J
12/01/17

QTY -05	QTY -06	QTY -07	QTY -08	QTY -09	QTY -10	PART NUMBER	DESCRIPTION	
X						D3140-05	DOOR	
	X					D3140-06	DOOR	
		X				D3140-07	DOOR	
			X			D3140-08	DOOR	
				1	X	D3140-09	DOUBLER ASSEMBLY	
					1	X	D3140-10	DOUBLER ASSEMBLY
3	3					D3140-57	PAD	
1	1					D3140-59	PAD	
2	2					D3140-61	PAD	
2	2					D3140-63	PAD	
		1	1			D3140-69	PAD	
			1			D3140-71	PAD	
				1		D3140-73	PAD	
					1	D3140-75	PAD	
					1	D3140-77	PAD	
					1	D3140-79	PAD	
					1	1	D3140-85	ANGLE
1	1					D3140-87	DOUBLER	
					1	1	D3140-89	DOUBLER
			1			D3140-91	DOUBLER	
				1		D3140-92	DOUBLER	
3	3					D3140-95	DOUBLER	
1						D3140-97	DOUBLER	
	1					D3140-98	DOUBLER	
		1	1			D3140-99	DOUBLER	
			2	2		D3140-101	DOUBLER	
			1			D3140-103	DOUBLER	
				1		D3140-104	DOUBLER	
				1		D3140-105	DOUBLER	
					1	D3140-106	DOUBLER	
1	1					D3140-241	DOUBLER	
1		1				D3140-301	DOUBLER	
	1		1			D3140-303	DOUBLER	
				5	5	MS20426AD3-4	RIVET	

D

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DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3140
DATE 06.10.06		REV. F SHEET 2 OF 7 TITLE DOOR SCALE NTS



1 COMPOSITE LAYUP & BONDING I.A.W. DELASTEK PROCESS SPEC. TEC-77
MATERIAL STORAGE & HANDLING TO BE I.A.W. DART QSI 006
MAIN LAYUP USES FIBERCOTE E-761/7781 EPOXY FIBERGLASS.
FILL WITH EPOCAST 87269 OR MAGNOBOND 77 A & B AND MA560 FOAM/ NB-51/30 FOAM



2 FINISH: DUPONT HIGHBUILD GREY PRIMER 1144-S



3 MAKE PARTS IN ACCORDANCE WITH THE FOLLOWING TOOLS/MOLDS:

PART	TOOL
D3140-05	B30-23000-01T
D3140-06	B30-23000-02T
D3140-07	B30-23000-03T
D3140-08	B30-23000-04T
D3140-57	B30-23000-57T
D3140-61	B30-23000-61T
D3140-63	B30-23000-63T
D3140-69	B30-23000-69T
D3140-71	B30-23000-71T
D3140-73	B30-23000-73T
D3140-75	B30-23000-75T
D3140-77	B30-23000-77T
D3140-79	B30-23000-79T
D3140-89	D3140-89T1
D3140-301	D3140-301T1
D3140-303	D3140-303T1

RELEASED

06-11-13



4 MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK (M2024T3S.032)
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1



5 MATERIAL: 2024-T3 (QQ-A-250/4) 0.020 THICK (M2024T3S.020)
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1



6 MATERIAL: 5052-H32/H34 (QQ-A-250/8) 0.040 THICK (M5052H32S.040)
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1



7 MATERIAL: POLIMEX TR75 1" THICK 4.5 LB KLEGECCELL



8 ALL DIMENSIONS IN INCHES



9 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



10 MATERIAL: 6061-T6 (QQ-A-250/11) 0.063 THICK (M6061-T6S.063)
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1



11 DOUBLER TO SIT ON TOP OF FOAM AT THIS LOCATION



12 DOUBLER TO BE RECESSED FLUSH INTO FOAM AT THIS LOCATION



13 RUBBER STAMP WITH DART P/N D3140-05/-06/-07/-08 USING MIL-STD-130



14 PARTS MUST BE SCUFFED WITH 80 GRIT SANDPAPER PRIOR TO ACID ETCH AND
ALODINE PER DART QSI 005 4.1



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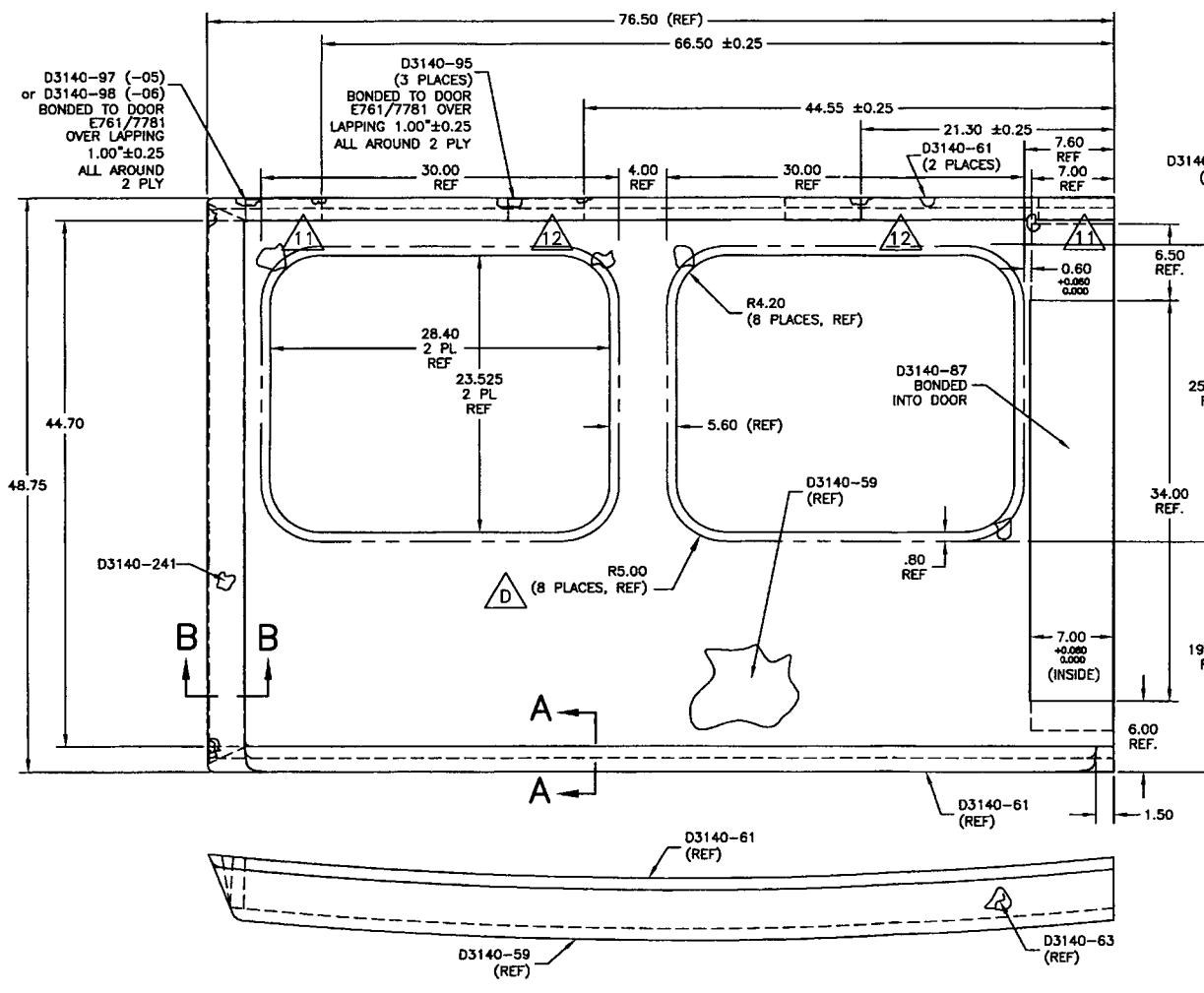
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78941



D3140-05 DOOR (SHOWN, REPLACES PREMIER P/N B30-23000-05)
D3140-06 DOOR (OPPOSITE, REPLACES PREMIER P/N B30-23000-06)
 (WINDOWS & CUTOUTS TO BE LOCATED PER B30-23000-01T/-02T TOOL)

1 2 3

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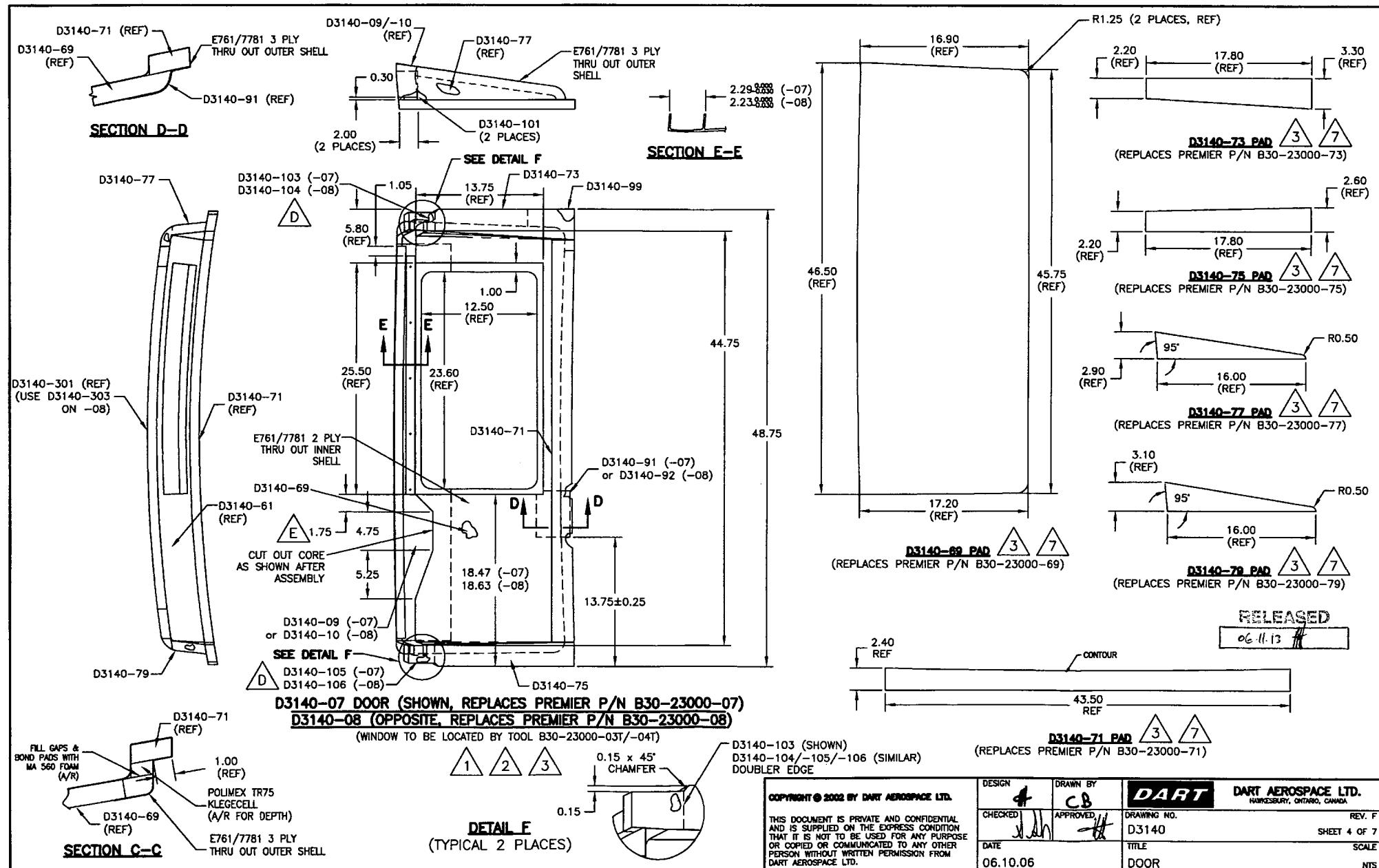
DESIGN	DRAWN BY	DART	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA
4	CB		
CHECKED	APPROVED	DRAWING NO.	REV. F
		D3140	SHEET 3 OF 7
DATE		TITLE	SCALE
06.10.06		DOOR	NTS

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries



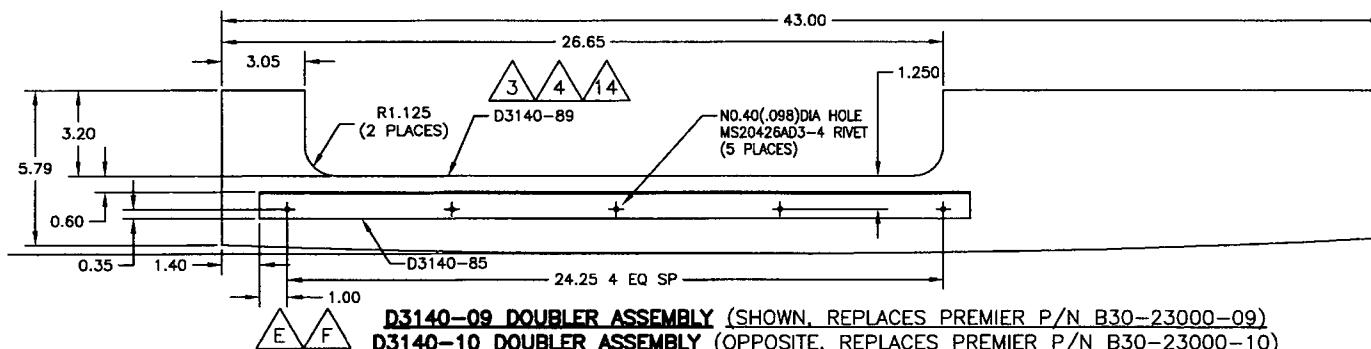
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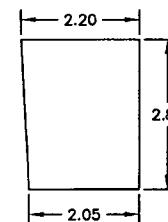
NOTE: Date & initial all entries

78941



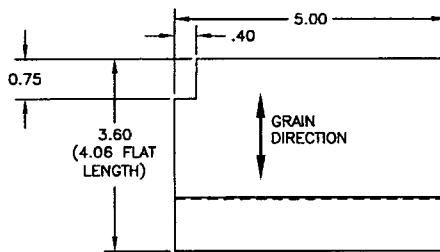
D3140-09 DOUBLER ASSEMBLY (SHOWN, REPLACES PREMIER P/N B30-23000-09)

D3140-10 DOUBLER ASSEMBLY (OPPOSITE, REPLACES PREMIER P/N B30-23000-10)



D3140-101 DOUBLER 4 14

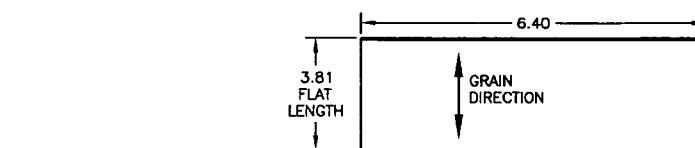
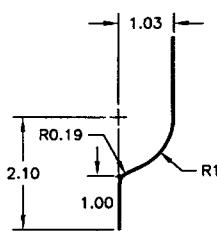
(REPLACES PREMIER P/N B30-23000-101)



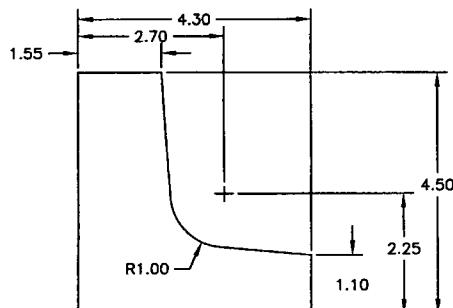
D3140-91F DOUBLER
(USE TO MAKE D3140-91/-92 DOUBLERS)

(SHOWN, REPLACES PREMIER P/N B30-23000-92)

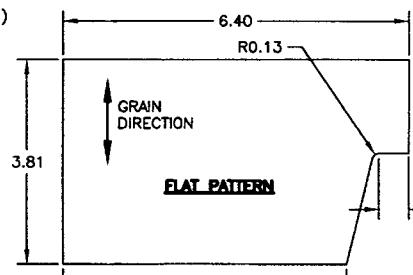
D3140-91 DOUBLER
(OPPOSITE, REPLACES PREMIER P/N B30-23000-91)



D3140-95 DOUBLER 4 14
(REPLACES PREMIER P/N B30-23000-95)



D3140-99 DOUBLER 4 14
(REPLACES PREMIER P/N B30-23000-99)

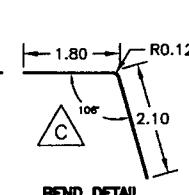


D3140-97F DOUBLER
(USE TO MAKE D3140-97/-98 DOUBLERS)

(SHOWN, REPLACES PREMIER P/N B30-23000-97)

D3140-98 DOUBLER
(OPPOSITE, REPLACES PREMIER P/N B30-23000-98)

RELEASED
06-11-13



BEND DETAIL

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DESIGN

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DART AEROSPACE LTD.
HAWKESBURY, ONTARIO, CANADA

REV. F

SHEET 5 OF 7

SCALE

NTS

DATE

06.10.06

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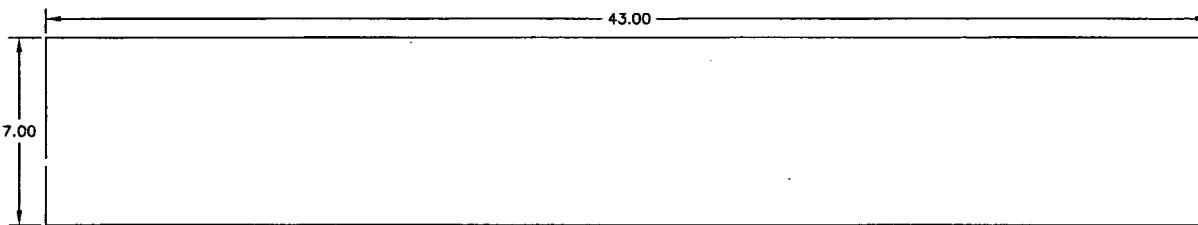
W/O:		WORK ORDER CHANGES					
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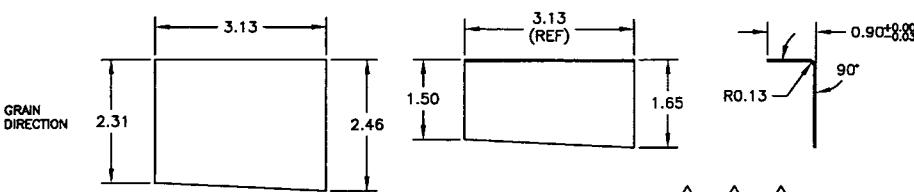
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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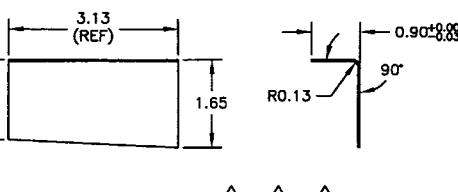
78941



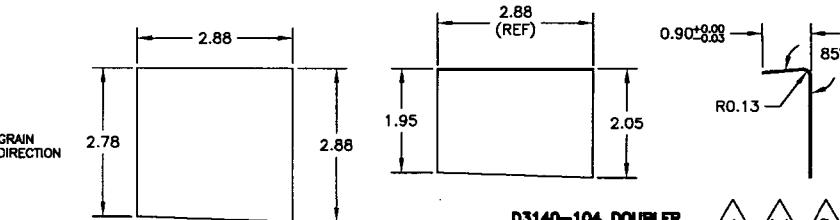
D3140-87 DOUBLER 4 14
(REPLACES PREMIER P/N B30-23000-87)



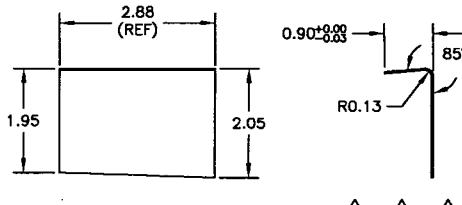
D3140-105F FLAT PATTERN
(USED TO MAKE D3140-105/-106 BRACKETS)



D3140-105 DOUBLER
D3140-106 OPPOSITE 4 14 D



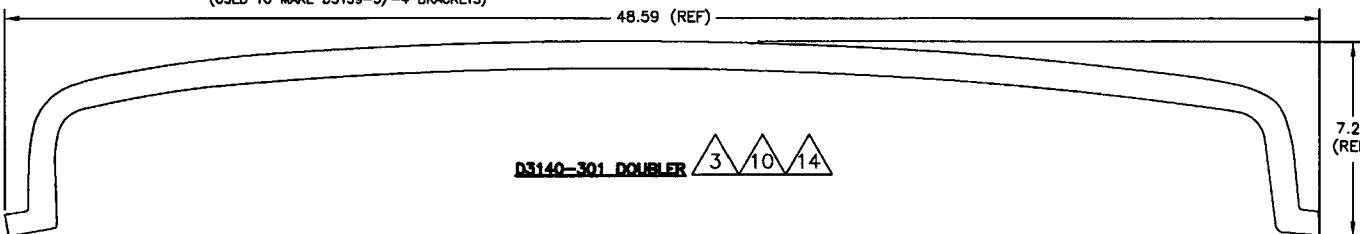
D3140-104 FLAT PATTERN
(USED TO MAKE D3140-103/-104 BRACKETS)



D3140-103 DOUBLER 4 14 D 14 F

D3159-3F FLAT PATTERN
(USED TO MAKE D3159-3/4 BRACKETS)

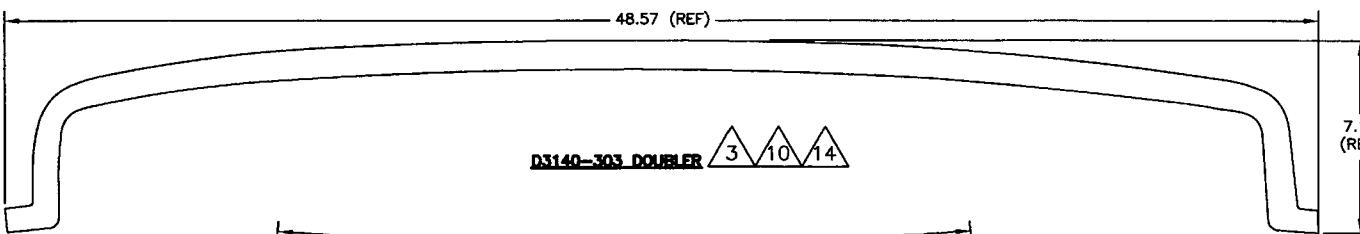
48.59 (REF)



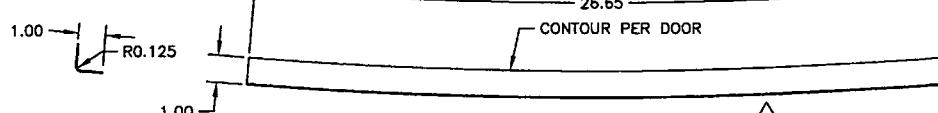
RELEASED
06/07/03

D3140-301 DOUBLER 3 10 14

48.57 (REF)



D3140-303 DOUBLER 3 10 14



D3140-85 ANGLE 6
FLAT PATTERN: 26.65" x 1.90"
(REPLACES PREMIER P/N B30-23000-85)

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DART AEROSPACE LTD.

DESIGN	DRAWN BY	DART	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA
4	CB		REV. F
CHECKED	APPROVED	D3140	SHEET 6 OF 7
06.10.06		TITLE DOOR	SCALE NTS

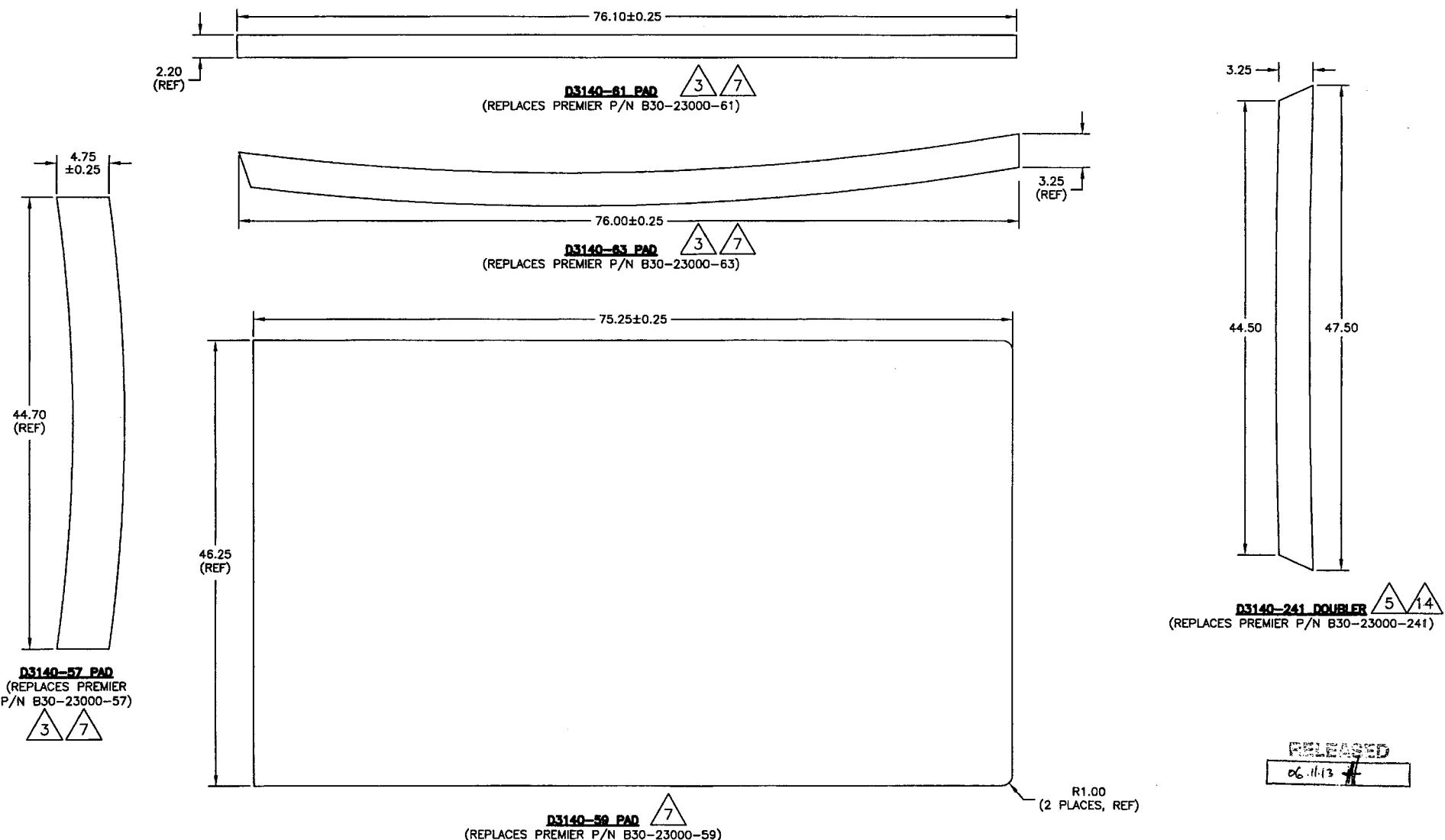
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

78941



D3140-59 PAD 7
(REPLACES PREMIER P/N B30-23000-59)

COPYRIGHT © 2002 BY DART AEROSPACE LTD.		DESIGN	DRAWN BY	DART	DART AEROSPACE LTD. HAWKSBURY, ONTARIO, CANADA
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO.	REV. F
				D3140	SHEET 7 OF 7
DATE	06.10.06	TITLE	DOOR	SCALE	NTS

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DELASTEK Inc.
2699 5e Avenue
Local 14, C.P.-10100
Grand-Mère, Québec G9T 5K7
Canada
Tel.: (819) 533-5788
Fax: (819) 533-3494

PACKING SLIP

CERTIFICATE OF COMPLIANCE

Invoice No.	47937
Customer No.	DART US

Bill To

DART AEROSPACE LTD
1270, Aberdeen Street
Hawksbury, Ontario K6A 1K7
Canada

Telephone : 613-632-5200
Contact : Linda Lacelle

Ship To

DART AEROSPACE LTD
1270, Aberdeen Street
Hawksbury, Ontario K6A 1K7
Canada



Telephone : 613-632-5200
Contact : Linda Lacelle

Ship Date	Order Date	Our SO #	Ordered by	Your PO#	Terms
03-05-2013	16-03-2012	20221	Chantal Lavoie	PO16439	Net 30 days USA
Ship Via		F.O.B.		Salesperson	GST/PST
Day & Ross Collect		Point de départ	Mathieu Doucet, ext.690		
Order Qty	B.O. Qty	Current Ship.	Item number	Description	
1	0	1	DKC135-0019	Line #2 D3140-06 Door Right Non Assy (Grosse) U of M: Chaque B78941 DWG D3140 REV. F Serial # 40734.	Lot # 40734
1	0	1	DKC135-0020	Line #4 D3140-08 Door Right Non Assy (Petite) U of M: Chaque B78943 DWG D3140.REV. F Serial # 40734.	Lot # 40734

43/6/17

It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request

Accepted by:

Quality department



AQ-357

 Cust. Adm. Quality Ship.

Feuille de Procédé

Client : DART US DART AEROSPACE LTD
Numéro Job : 40734
Numéro Soumission : 3407
Numéro B.A. :
Cette fois : 2012-04-26 No. B.V. :
Prsht Rev. : NC
Prém. fois : -- Type :
Job précédente : 40172

Écrit par

Vérifié & Approuvé par
Commentaires

Nom Dessin : DOOR KIT
Numéro Article : DKC135-0019/0020
Numéro Dessin : D3140
Projet Numéro : DK-359
Révision dessin : F
Matériel : Fibercote E-761
Date Dûe : 2012-07-02

Qté: 1 UdM: UNITE

N° de pièce Client: D3140-06/-08

Process Sheet Rév.: 05 remplacer AAC0559 et AAC0563 par
AAC2032 et AAC1361 respectivement, changé AC0883 et AC0884
par AAC1885 et AAC1887 respectivement à 2 endroits qui avait
étés oubliés

RNC707

Produit additionnel

Numéro Job:



# Séq.:	Machine ou Opération:	Description:
1.0	AAC0854	Frékote #700-NC
	Commentair Qty.: 0.030 UNITE(s)/Unit Total : 0.030 UNITE(s) Frékote #700-NC N° de Lot: 1-33991-1	
2.0	PRÉPARATION	Préparation du moule
	Commentair Setup: 0.00Hrs/ Run: 130.0000Min Total Run : 2.1667Hrs Faire la préparation du moule selon JF135-0002 et JS-0009.	
	Date: 18-09-12 Sceau:	
3.0	AMB0211	Epoxy preprep E-761 style 7781
	Commentair Qty.: 12.30 VERGE(s)/Unit Total : 12.30 VERGE(s) Epoxy preprep E-761 style 7781 N° de Lot: 1-35874-1	
4.0	DECOUPE	Découpe manuelle des pièces
	Commentair Setup: 0.00Hrs/ Run: 60.0000Min Total Run : 1.0000Hrs Découpe des tissus pré-impregné E-761 en paquet de 10.5 pi. (7 Paquet = 24.5 verges)	
	Quantité: 1 Date: 18-09-12 Sceau:	

Date: Jeudi, 2012-04-26 14:13:59
Utilisateur: marc dubé

Feuille de Procédé

Client: DARTUS DART AEROSPACE LTD
Numéro Job: 40734

Nom Dessin: DOOR KIT

Numéro Article: DKC135-0019-0020

Numéro Job:



Séq.:

Machine ou Opération:

Description:

5.0 DRAPAGE

Drapage



Commentair Setup: 0.00Hrs/ Run: 12.0000Hrs Total Run : 12.0000Hrs

Faire le drapage de 3 plis de tissus E-761 (4 Paquets) selon IF135-0002

Quantité: 1

Date: 19-09-12 Sceau:



6.0 AAC1885

Tissu à délaminer Release ply B

Commentair Qty.: 4.37 VERGE(s)/Unit Total: 4.37 VERGE(s)

Tissu à délaminer Release ply B

de Lot: 2-31883-1

7.0 AAC1887

Wrighton 5200 Bleu P3

Commentair Qty.: 7.18 VERGE(s)/Unit Total: 7.18 VERGE(s)

Wrighton 5200 Bleu P3

de Lot: 1-3375-2

8.0 AC0885

Feutre de drainage N° Airweave N 10

Commentair Qty.: 6.00 VERGE(s)/Unit Total: 6.00 VERGE(s)

9.0 AC0882

Sac à vide N° Stretchlon 700

Commentair Qty.: 7.770 VERGE(s)/Unit Total: 7.770 VERGE(s)

10.0 AC0886

Ruban à gommer jaune #: T/AT-200Y

Commentair Qty.: 2.0000 ROULEAU(s)/Unit Total: 2.0000 ROULEAU(s)

11.0 BAGGING

Faire le bagging sur la pièce



Commentair Setup: 0.00Hrs/ Run: 180.0000Min Total Run : 3.0000Hrs

Faire le bagging sur la pièce selon IF135-0002 et IG 0012.

Quantité: 1

Date: 20-09-12 Sceau:



12.0 CUISSON

Cuisson de pièce



Commentair Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs

Faire la cuisson de la pièce selon IF135-0002, IG 0012 et PTN #20. N° Cuisson: 70-12



13.0 DÉMOULAGE

Démoulage de la pièce



Commentair Setup: 0.00Hrs/ Run: 240.0000Min Total Run : 4.0000Hrs

Retirer le montage cuisson et faire les retouches de la pièce afin d'enlever les surplus de résine et les résidus de tissus à délaminer.

Date: Jeudi, 2012-04-26 14:13:59
Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE LTD	Nom Dessin: DOOR KIT
Numéro Job: 40734	Numéro Article: DKC135-0019-0020
Numéro Job:	
# Séq.:	Machine ou Opération: Description :
14.0	Quantité: 1 Date: 24-09-12 Sceau:
	INSPECTION Inspection générale
	Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs
	Inspection de la première coquille par le département de la qualité pour s'assurer qu'il n'y aie pas de réparation à faire avant la prochaine étape.
15.0	Quantité: 1 Date: 21-12-12 Sceau:
	AAC1618 Rohacell 71S 1"thick 49.2" x 98.4" plain
	Commentair Qty.: 2.000 FEUILLE(s)/Unit Total: 2.000 FEUILLE(s) Rohacell 71S 1"thick 49.2" x 98.4" plain N° de Lot: 1-37808-2
16.0	DECOUPE Découpe manuelle des pièces
	Commentair Setup: 0.00Hrs/ Run: 900.0000Min Total Run : 15.0000Hrs
	Faire la découpe des pièces de mousse structurelles (Rohacell) sur la scie à ruban selon IF135-0002.
17.0	Quantité: 1 Date: 04/12/12 Sceau:
	SÉCHAGE/ANEAL Séchage / Annealing
	Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs
	Faire le séchage du Rohacell selon IF135-0002 et les informations du manufacturier. N° Cuisson: 7518
18.0	Quantité: 1 Date: 29/11/12 Sceau:
	AMB0442 Film adhesif de EA9696 36" large x 0.06 (psf)
	Commentair Qty.: 6.12 VERGE CAR(s)/Unit Total: 6.12 VERGE CAR(s) Film adhesif de EA9696 36" large x 0.06 (psf) N° de Lot: 2-35855-2
19.0	AAC2032 Core splice adhesive NB-51/301
	Commentair Qty.: 5.0 PIED CARRE(s)/Unit Total: 5.0 PIED CARRE(s) Core splice adhesive NB-51/301 # de Lot: 1-36395-1
20.0	AAC1361 Putty AD Tech P-17
	Commentair Qty.: 0.50 UNITE(s)/Unit Total: 0.50 UNITE(s) Putty AD Tech P-17 # de Lot: 1-38354-2

Date: Jeudi, 2012-04-26 14:13:59
Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE LTD
Numéro Job: 40734

Nom Dessin: DOOR KIT
Numéro Article: DKC135-0019/-0020

Numéro Job:



Séq.: Machine ou Opération: Description:

21.0 AAC1646 N° D3140-10, Doubler

Commentair Qty.: 1 UNITE(s)/Unit Total : 1 UNITE(s)
N° D3140-10, Doubler N° de Lot: 1-37826-1

22.0 AAC1631 N° D3140-87, Doubler

Commentair Qty.: 1 UNITE(s)/Unit Total : 1 UNITE(s)
N° D3140-87, Doubler N° de Lot: 1-37871-1

23.0 AAC1633 N° D3140-92, Doubler

Commentair Qty.: 1 UNITE(s)/Unit Total : 1 UNITE(s)
N° D3140-92, Doubler N° de Lot: 1-37826-2

24.0 AAC1634 N° D3140-95, Doubler

Commentair Qty.: 3 UNITE(s)/Unit Total : 3 UNITE(s)
N° D3140-95, Doubler N° de Lot: 1-37826-19

25.0 AAC1636 N° D3140-98, Doubler

Commentair Qty.: 1 UNITE(s)/Unit Total : 1 UNITE(s)
N° D3140-98, Doubler N° de Lot: 1-37826-20

26.0 AAC1637 N° D3140-99, Doubler

Commentair Qty.: 1 UNITE(s)/Unit Total : 1 UNITE(s)
N° D3140-99, Doubler N° de Lot: 1-37826-3

27.0 AAC1638 N° D3140-101, Doubler

Commentair Qty.: 2 UNITE(s)/Unit Total : 2 UNITE(s)
N° D3140-101, Doubler N° de Lot: 1-37826-4

28.0 AAC1640 N° D3140-104, Doubler

Commentair Qty.: 1 UNITE(s)/Unit Total : 1 UNITE(s)
N° D3140-104, Doubler N° de Lot: 1-37826-5

29.0 AAC1642 N° D3140-106, Doubler

Commentair Qty.: 1 UNITE(s)/Unit Total : 1 UNITE(s)
N° D3140-106, Doubler N° de Lot: 1-37826-6

30.0 AAC1643 N° D3140-241, Doubler

Commentair Qty.: 1 UNITE(s)/Unit Total : 1 UNITE(s)
N° D3140-241, Doubler N° de Lot: 1-37826-10

31.0 AAC1645 N° D3140-303, Doubler

Commentair Qty.: 2 UNITE(s)/Unit Total : 2 UNITE(s)
N° D3140-303, Doubler N° de Lot: 1-37826-7 et 1-37826-22

32.0 NETTOYAGE Nettoyage des pièces



Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs

Faire le nettoyage des doublers selon IG 0063.

Quantité: 1 Date: 23-1-2013 Sceau:

-Date:
Utilisateur:

Jeudi, 2012-04-26 14:13:59
marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE LTD
Numéro Job: 40734

Nom Dessin: DOOR KIT
Numéro Article: DKC135-0019/-0020

Numéro Job:



Séq.:

Machine ou Opération:

Description :

33.0

ASSEMBLAGE

Assemblage mécanique



Commentair Setup: 960.0Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Mise en place des doublers et des pièces de la mousse structurale selon IF135-0002.

Quantité:

Date: 24-1-2013

Sceau:



34.0

AAC1885

Tissu à délaminer Release ply B

Commentair Qty.: 4.37 VERGE(s)/Unit Total : 4.37 VERGE(s)

35.0

AAC1887

Wrighton 5200 Bleu P3

Commentair Qty.: 7.18 VERGE(s)/Unit Total : 7.18 VERGE(s)

36.0

AC0885

Feutre de drainage N° Airweave N 10

Commentair Qty.: 6.00 VERGE(s)/Unit Total : 6.00 VERGE(s)

37.0

AC0882

Sac à vide N° Stretchion 700

Commentair Qty.: 7.770 VERGE(s)/Unit Total : 7.770 VERGE(s)

38.0

AC0886

Ruban à gommer jaune #: T/AT-200Y

Commentair Qty.: 2.0000 ROULEAU(s)/Unit Total : 2.0000 ROULEAU(s)

39.0

BAGGING

Faire le bagging sur la pièce



Commentair Setup: 0.00Hrs/ Run: 180.0000Min Total Run : 3.0000Hrs

Faire le montage cuisson selon IF135-0002 et IG 0012.

Quantité:

Date: 24-81-2013

Sceau:



40.0

CUISSON

Cuisson de pièce



Commentair Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs

Faire la cuisson de la pièce selon IF135-0002, IG 0012 et PTN #21. N° Cuisson: 7036

Quantité:

Date: 25-01-13

Sceau:

4254 m C

41.0

DÉMOULAGE

Démoulage de la pièce



Commentair Setup: 0.00Hrs/ Run: 60.0000Min Total Run : 1.0000Hrs

Retirer le montage cuisson de sur la pièce et enlever les résidus de ruban adhésif en teflon et les barres d'aluminium. Garder seulement la barre qui sépare les deux pièces.

Quantité:

Date: 28/01/13

Sceau:



Date: Jeudi, 2012-04-26 14:13:59
Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE LTD
Numéro Job: 40734

Nom Dessin: DOOR KIT
Numéro Article: DKC135-0019/-0020

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
42.0	DECOUPE 	Découpe manuelle des pièces Commentair Setup: 0.00Hrs/ Run: 900.0000Min Total Run : 15.0000Hrs Usinage des mousses structurales selon IF135-0002 et installer les doublers
	Quantité: 1 Date: 7/02/13	Sceau:
43.0	INSPECTION 	Inspection générale Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs Faire la vérification de l'usinage intérieur pour s'assurer que tout soit conforme au dessin avant la prochaine étape.
	Quantité: 1 Date: 7/02/13	Sceau:
44.0	AMB0211 	Epoxy prepeg E-761 style 7781 Commentair Qty.: 12.30 VERGE(s)/Unit Total : 12.30 VERGE(s) Epoxy prepeg E-761 style 7781 N° de Lot: 36396-1
45.0	DRAPAGE 	Drapage Commentair Setup: 0.00Hrs/ Run: 12.0000Hrs Total Run : 12.0000Hrs Drapage de la coquille intérieure selon IF135-0002
	Quantité: 1 Date: 7/02/13	Sceau:
46.0	AAC1885 	Tissu à délaminer Release ply B Commentair Qty.: 4.37 VERGE(s)/Unit Total : 4.37 VERGE(s)
47.0	AAC1887 	Wrighton 5200 Bleu P3 Commentair Qty.: 7.18 VERGE(s)/Unit Total : 7.18 VERGE(s)
48.0	AC0885 	Feutre de drainage N° Airwéave N 10 Commentair Qty.: 6.00 VERGE(s)/Unit Total : 6.00 VERGE(s)
49.0	AC0882 	Sac à vide N° Stretchion 700 Commentair Qty.: 7.770 VERGE(s)/Unit Total : 7.770 VERGE(s)
50.0	AC0886 	Ruban à gommer jaune #: T/AT-200Y Commentair Qty.: 2.0000 ROULEAU(s)/Unit Total : 2.0000 ROULEAU(s)

Date:
Utilisateur:

Jeudi, 2012-04-26 14:13:59
marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE LTD
Numéro Job: 40734

Nom Dessin: DOOR KIT
Numéro Article: DKC135-0019/-0020

Numéro Job:



Séq.:

Machine ou Opération:

Description :

51.0

BAGGING

Faire le bagging sur la pièce



Commentair Setup: 0.00Hrs/ Run: 180.0000Min Total Run : 3.0000Hrs

Faire le montage cuisson selon IF135-0002 et IG 0012.

Quantité: 1

Date: 29-02-13

Sceau: 7



52.0

CUISSON

Cuisson de pièce



Commentair Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs

Faire la cuisson de la pièce selon IF135-0002, IG 0012 et PTN #20. N° Cuisson: 7412

Quantité: 1

Date: 29/02/12

Sceau: 254

53.0

DÉMOULAGE

Démouillage de la pièce



Commentair Setup: 0.00Hrs/ Run: 60.0000Min Total Run : 1.0000Hrs

Retirer le montage cuisson et faire des retouches sur la pièce afin d'enlever les surplus de résine et les résidus de tissus à délaminer.

Retirer la pièce du moule.

Quantité: 1

Date: 29-2-2013

Sceau:



54.0

INSPECTION

Inspection générale



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire l'inspection par le département de la qualité "Tap test et inspection dimensionnelle".

Quantité: 1

Date:

Sceau:

Non fait par QA



16 avril 2013
IV

55.0

TRIMAGE

Trimage



Commentair Setup: 0.00Hrs/ Run: 180.0000Min Total Run : 3.0000Hrs

Faire le trimage de finition de la pièce selon IF135-0003.

Quantité: 1

Date: 29-2-2013

Sceau:



12-04-2013
4435

Date: Jeudi, 2012-04-26 14:13:59
Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE LTD
Numéro Job: 40734

Nom Dessin: DOOR KIT

Numéro Article: DKC135-0019/0020

Numéro Job:



Séq.:

Machine ou Opération:

Description :

56.0 AAC1021

Dupont Primer N° 7704S

à partie

Commentair Qty.: 0.5000 UNITE(s)/Unit Total: 0.5000 UNITE(s)
Dupont Primer N° 7704S N° de Lot: 1-36493-1

Lot: 1-37303-1

57.0 AAC1101

N° 7775S, Dupont Activator - Reducer Chromabase

à partie

Commentair Qty.: 0.0283 UNITE(s)/Unit Total: 0.0283 UNITE(s)
N° 7775S, Dupont Activator - Reducer Chromabase N° de Lot: 1-38821-1

Lot: 1-38821-1

58.0

PRIMER

Application primer



Commentair Setup: 0.00Hrs/ Run: 60.0000Min Total Run : 1.0000Hrs

première partie 01-03-13

Faire l'application du primer selon IG 0008.

à partie

Quantité:

1

Date: 16-04-13 Sceau: 437900 N° fiche Mélange: N/A

59.0

SABLAGE

Sablage



Commentair Setup: 0.00Hrs/ Run: 240.0000Min Total Run : 4.0000Hrs

Faire le sablage du primer selon IF135-0003.

Quantité:

1

Date: 15/03/13 Sceau: 57

18/04/13 4433MM

60.0

PRIMER

Application primer



Commentair Setup: 0.00Hrs/ Run: 60.0000Min Total Run : 1.0000Hrs

première partie 05-03-13



Faire l'application du primer selon IG 0008.

à partie

Quantité:

1

Date: 18-04-13 Sceau: 57

N° fiche Mélange: N/A

61.0

IDENTIFICATION

Identification des pièces



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs

Faire l'identification des pièces sur l'aluminium peinturé dans le dégagement des mécanismes de porte selon IG 0055.

N° de pièce Grosse porte: D3140-06

N° de pièce Petite porte: D3140-08

N° de Job (sur les 2 pièces): 40734

Date de fabrication (sur les 2 pièces): 06/03/2013 19/04/2013

Sceau d'inspection.

19/04/2013

Quantité:

1

Date: 16/03/13 Sceau: 57

Date:
Utilisateur:

Jeudi, 2012-04-26 14:13:59
marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE LTD
Numéro Job: 40734

Nom Dessin: DOOR KIT

Numéro Article: DKC135-0019-0020

Numéro Job:



Séq.:

Machine ou Opération:

Description :

62.0

INSPEC FINAL

Inspection finale



Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs

Faire l'inspection finale des pièces par le département de la qualité selon le dessin D3140.

Quantité: 1 Kit

Date: 23 avr. 13 Sceau:



63.0

EMBAL / ENTREPO

Emballage & Entreposage



Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs

Emballer et entreposer selon IG 0057.

Quantité:

Kit

Date: 3/5/13 Sceau:





RNC
RAPPORT DE NON-CONFORMITÉ- PLAINTES CLIENTS
AQ-15

No.RNC

7271

IDENTIFICATION DE LA PIÈCE

Fournisseur	Client	Numéro dessin	Rev	Numéro de Pièces
Delastek Aéronautique	Dart Aerospace Ltd.	D3140-06-08	F	DK-359- -
No de commande	Nom du produit	No Travail	No Série	Article
N/A	DOOR KIT	40734	N/A	DKC135-0019-002
Garantie (Oui/Non)	NON			
				Quantité 1

DESCRIPTION DE LA NON-CONFORMITÉ

Cause	Mauvaise adhérence	Responsabilité	Composite
Situation requise		Situation actuelle	
Aucune bulles entre les tissus		Suite à l'inspektion de tap test, il y a des bulles d'air qui ont été emprisonné entre les tissus.	

IMPACTS DES FAUTES	(OUI/NON)	COUT ASSOCIÉ
EFFET SUR PRODUITS ENVIRONNEMENT	NON	Si vous détailler les fautes
EFFET SUR PRODUITS SEMBATOIS	NON	Disposition des produits affectés
EFFET SUR PRODUITS INTÉRES	NON	
Autres effets réels ou potentiel	NON	N/A

DISPOSITION DU PRODUIT NON CONFORME

Accouplée	Retourne	Dégradation	X	Réparation	Rebut	Autres

DÉTAIL SUR LA DISPOSITION

Persez un trou de 1/8" aux endroits en fautes.

No Travail de réparation :

N/A

Conformité après correction

OUI NON

Disposition finale:

N/A

ACTION PRÉVENTIVE/CORRECTIVE REQUISE

NON OUI Numéro : N/A

COMPLÉTÉ PAR LE SERVICE APRESVENTE (SI REQUIS)		
BON LIVRAISON	N/A	BON ARRIVÉ
INFORME	N/A	RNC CERTIFIÉ
DATE RECEPTION	N/A	WARRANTY
DATE EXPÉDITION	N/A	CERTIFICATE

COUT DE LA NON CONFORMITÉ

ADMINISTRATION	35,00 \$
DATE RECEPTION	- \$
INFORME	- \$
DATE EXPÉDITION	- \$
TRANSPORT	- \$
AUTRE	- \$
TOTAL	35,00 \$

Devise:

 USD CAD

AUTHENTIFICATION

COMPLÉTÉ PAR Isabelle Veillette

DATE 2013-02-28

SCEAU

INSPECTÉ PAR Isabelle Veillette

DATE 2013-02-28

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APPROUVÉ PAR

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